

# Work Order ID 669598

Thursday, May 12, 2011 3:25:02 PM



Page 1

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Item Name: Guide Assembly

Stop



Start Date: 5/12/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3572

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut Tube D3572-1 as per Dwg D3572  
2-deburr both ends

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

4X Ø m-f 11/05/18  
12

4X Ø m-f 11/05/18

(44)

8 11/05/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69598**

Thursday, May 12, 2011 3:25:02 PM

Page 2

Item ID: D3572-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Guide Assembly

Start Date: 5/12/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Weld per dwg A/R Aluminum rod Batch: M11457d 0.00

Large Fab

Memo

0.00

Large Fab

Large Fab

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572  
2- grind weld flush at the end of tube onlyR 12-1-10 (X4)

140

QC9- Inspect visual per QS1004- Fusion Welds

0.00

Memo

0.00

QC

Quality Control

xH 0 RE 12-01-10

150

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

QC

Quality Control

8/2/10/10(X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 69598**

Thursday, May 12, 2011 3:25:02 PM



Page 3

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide Assembly

Start Date: 5/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

④ ~~CF/BL 12-1-11~~

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:00  
320°F  
3:30

4X4 M-1 12/01/11

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

H BL 12-1-12

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 69598**

Page 4

Thursday, May 12, 2011 3:25:02 PM

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide Assembly

Start Date: 5/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

Identify as per dwg & Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

12/1/16  
10  
J  
4

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/1/16  
MF  
12-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, May 12, 2011 3:25:08 PM

Page 1

Work Order ID: 69598

Parent Item: D3572-041

Parent Item Name: Guide Assembly



Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 6.00

Required Qty: 6.00

## Comments:

IPP Rev:A New Issue 07-02-07 JLM  
 IPP rev B revB dwg EC  
 IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM  
 IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6T1.000W.188

Purchased

No

110

f

26.5224

2.34

14.77895



6061T6 RD TUBE 1.00 X .188W

### Location

### Loc Qty

### Loc Code

MAT016

26.522368

109041

3

111885

12

2x 114089

5.147368

2x 115868

6.375

D3572-3

Manufactured

No

130

Each

32.0000

4

24



Guide

### Location

### Loc Qty

### Loc Code

WA030

32

65088

2

65255

30

D3572-5

Manufactured

No

130

Each

6.0000

1

6



Bracket

### Location

### Loc Qty

### Loc Code

WA030

6

65100

6

69934

x 2

M-1 11/05/18

~~14.77895~~  
 4.9263  
 4.9263

EL 12-1-20

16.

EL 12-1-20

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

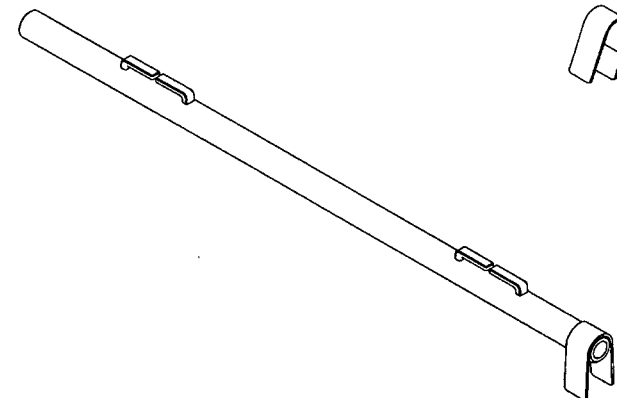
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

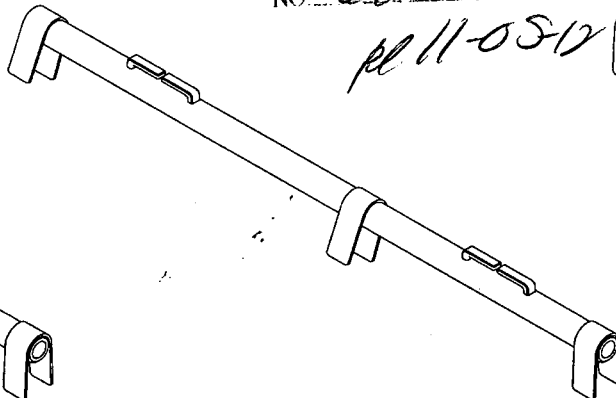
**NOTE:** Date & initial all entries

ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

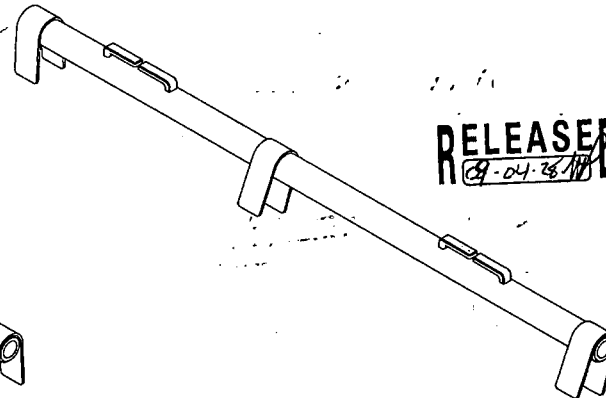
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 09598  
PL 11-0510



**D3572-041 GUIDE ASSEMBLY**



**D3572-043 GUIDE ASSEMBLY (UH-1)**



**D3572-044 GUIDE ASSEMBLY (UH-1)**

**RELEASED**  
09-04-17

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs  
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3572</b> REV. D SHEET 1 OF 4 TITLE <b>GUIDE ASSEMBLY</b> SCALE NTS COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.04.17		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

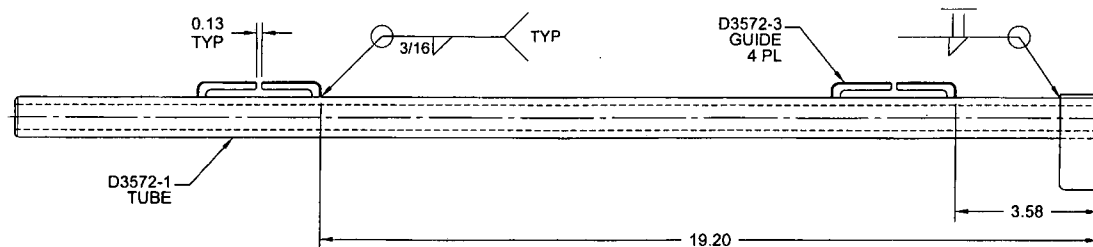
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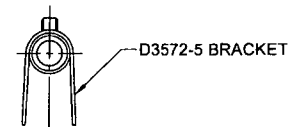
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

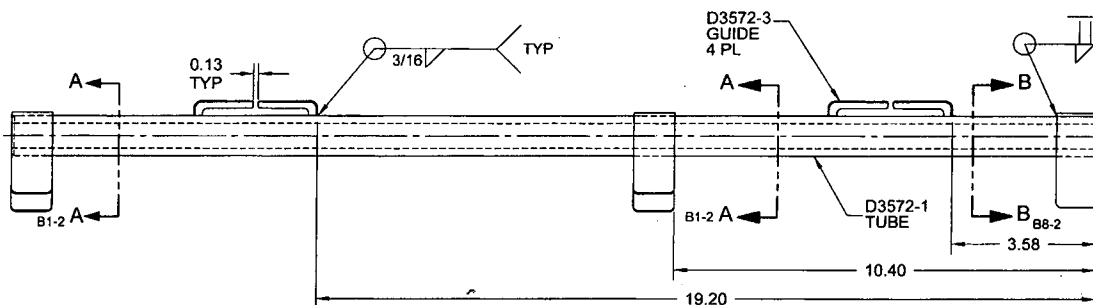
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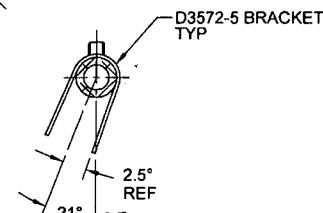
**D3572-041 GUIDE ASSEMBLY**



D3572-5 BRACKET



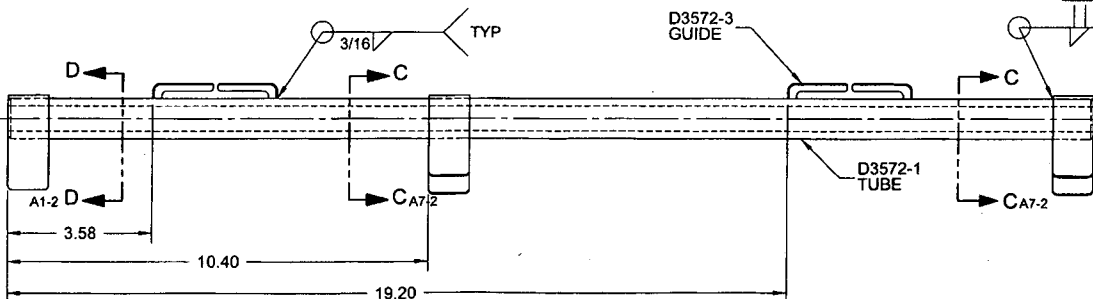
**D3572-043 GUIDE ASSEMBLY**



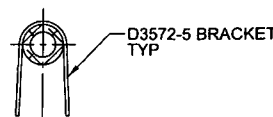
**SECTION A-A** C7-2  
(2 PL) C4-2

D3572-5 BRACKET REF

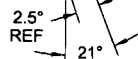
**SECTION B-B** C2-2



**D3572-044 GUIDE ASSEMBLY**



**SECTION D-D** A7-2



**SECTION C-C** A2-2  
A5-2

**RELEASED**  
09.04.17

W/O 09598

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MFG. APPR.	<i>[Signature]</i>	D3572	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GUIDE ASSEMBLY	NTS
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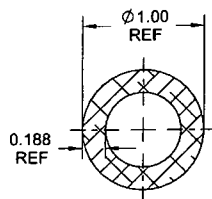
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

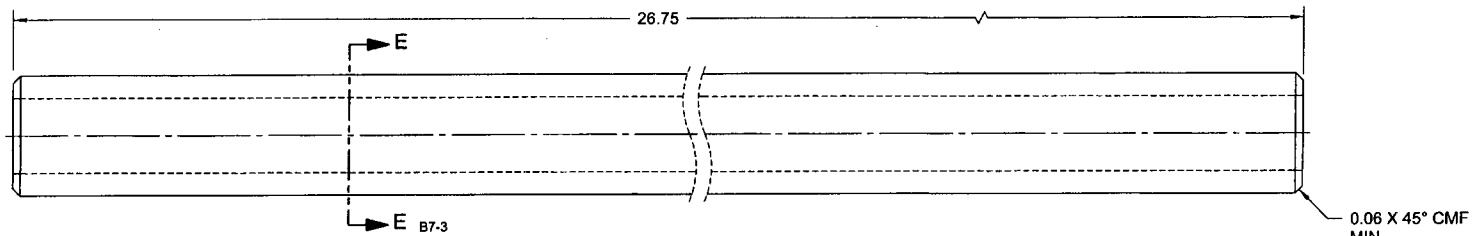
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**SECTION E-E** C5-3



**D3572-1 TUBE**

u/o 69598

**RELEASED**  
09/04/13

**D3572-1 NOTES:**

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

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DRAWN	AJS		
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MFG. APPR.		D3572	SHEET 3 OF 4
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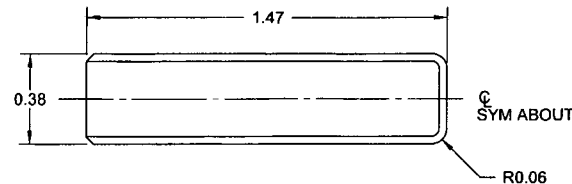
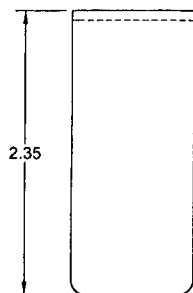
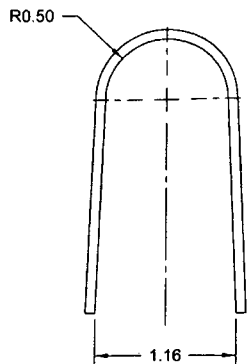
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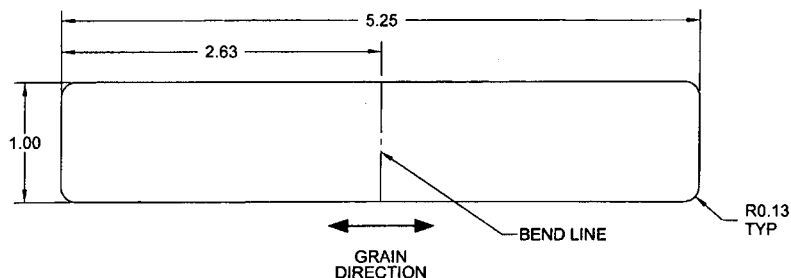
**NOTE:** Date & initial all entries



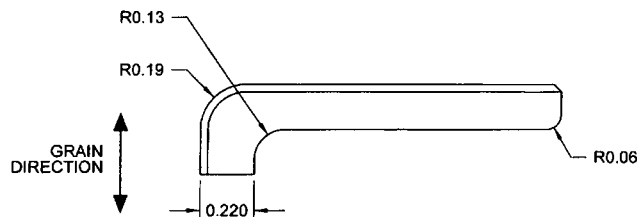
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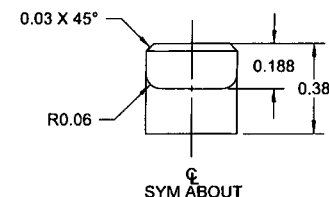
**D3572-5 BRACKET**  
(MAKE FROM D3572-5F)



**D3572-5F FLAT PATTERN**



**D3572-3 GUIDE**



ULO 69598

**RELEASED**  
9/04/17

**D3572-3 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
AMS-QQ-A-200/8 (OR AMS4160)  
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

**D3572-5 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D3572</b>	SHEET 4 OF 4
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries